

Work Order ID 85498

June-08-12 1:09:12 PM

85498

Page 1

Item ID: D4095-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad Assembly

Start Date: 6/08/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/12/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

304 1063

FLOW WATER JET

Memo

1-Cut as per Dwg (D4095-7)

Dwg Rev: 8

Prog Rev: 3

2-Deburr if necessary

0.00

12

0

Jm

12-6-9

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

12

0

Jm

12-6-9

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

8/2/11

412

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Page 2

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Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Assembly
 Start Date: 6/08/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/12/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				(12)			SB 12/06/11
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512/06/11		(42)			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>7121879</u> Large Fab Memo	0.00 0.00				(x12)		MAL	12/06/13

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Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Assembly
 Start Date: 6/08/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/12/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				12x		CP 12.06.14	
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				12		12.06.14	
180 *180* HandFinish Hand Finishing	Memo COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 121960	0.00 0.00				12		12/06/14	

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Page 4

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Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Assembly
 Start Date: 6/08/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/12/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190						12x	0	12/6/15	
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-7</u>	0.00							
200						12x	0	12/6/15	
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MF
12-06-15

Picklist Print

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Page 1

Work Order ID: 85498

Parent Item: D4095-047

Parent Item Name: Wearpad Assembly

Start Date: 6/08/12

Required Date: 6/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No				sf	122.6624		1.764			

Location

Loc Qty

Loc Code

MAT020

122.662433

121626

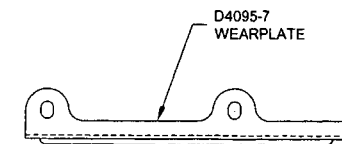
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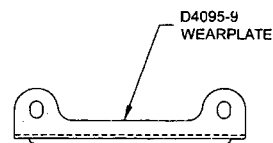
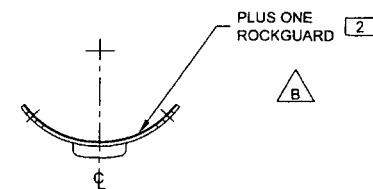
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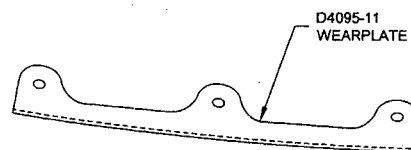
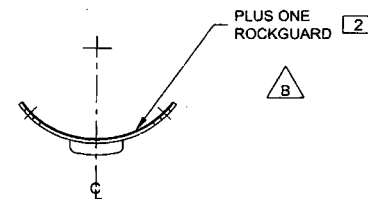
Jm
12-6-9



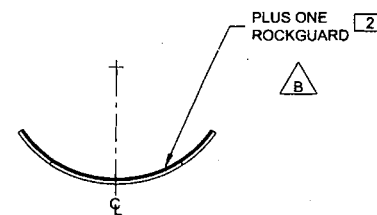
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



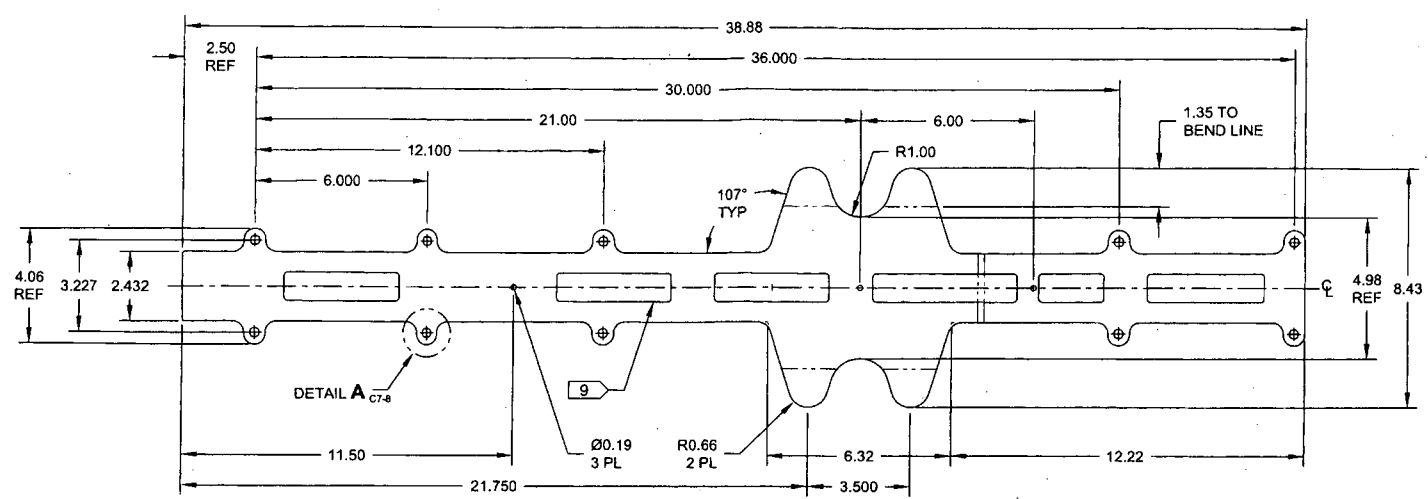
D4095-051 WEARPAD ASSEMBLY



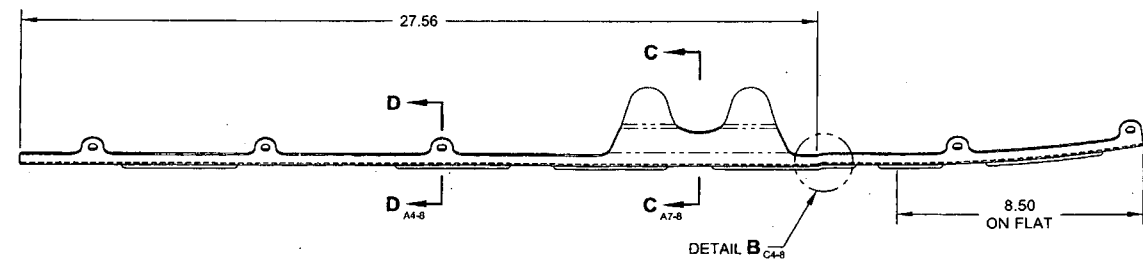
alossuys

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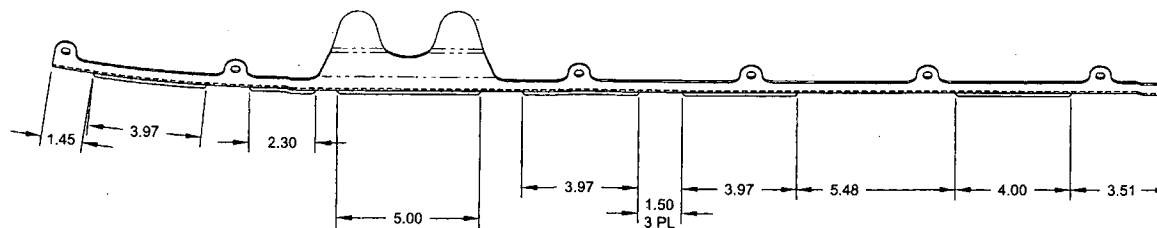
D4095-3F FLAT PATTERN 1



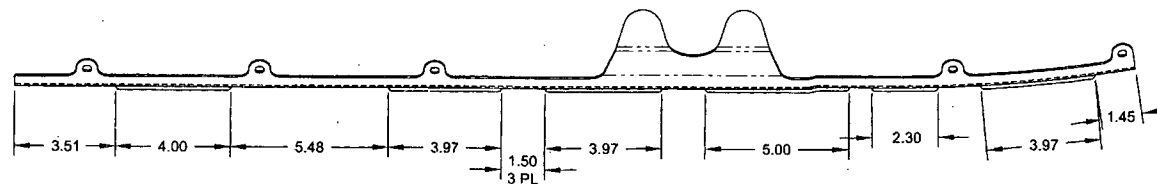
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

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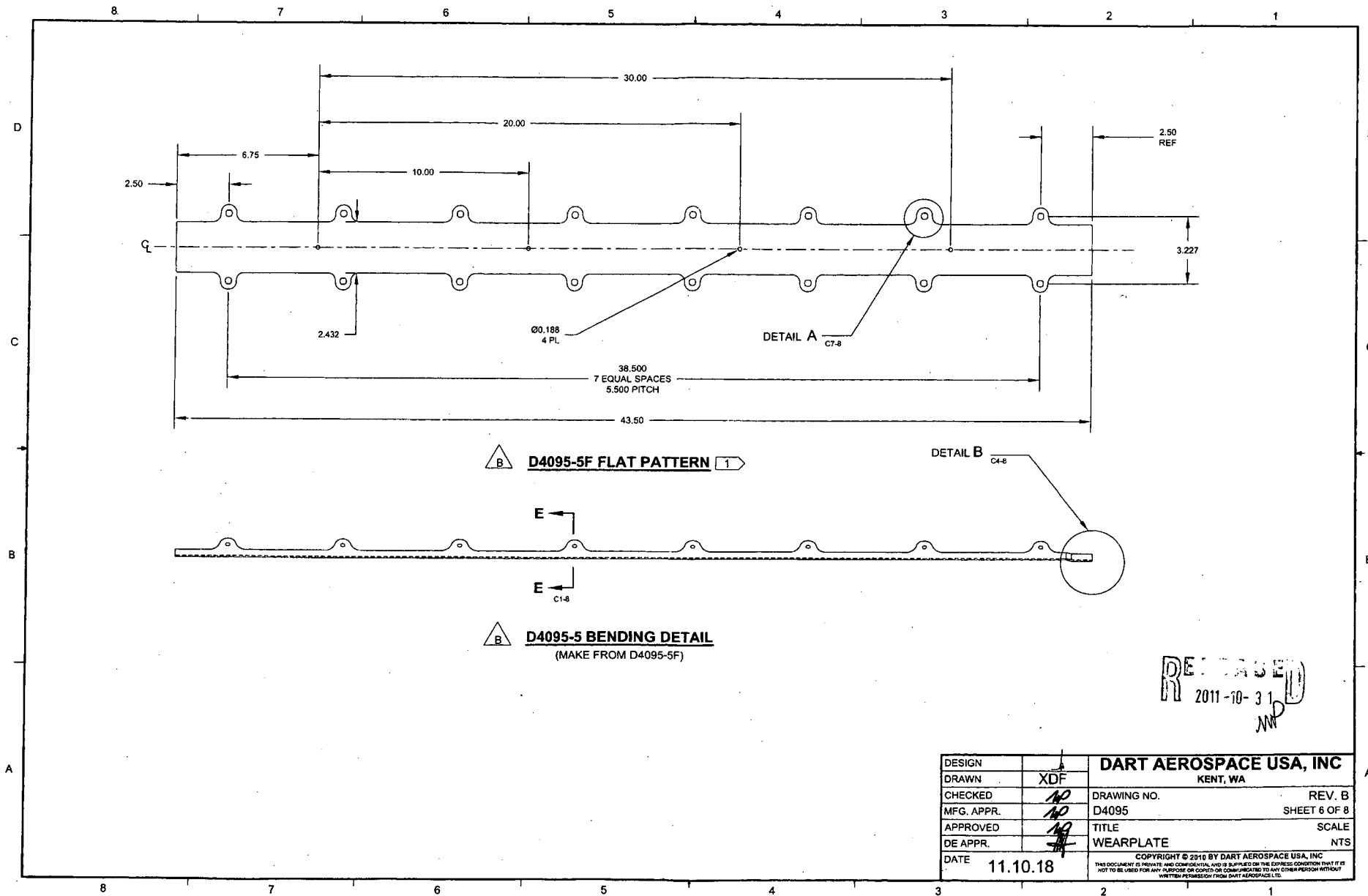
D4095-1 WELDING DETAIL



D4095-3 WELDING DETAIL

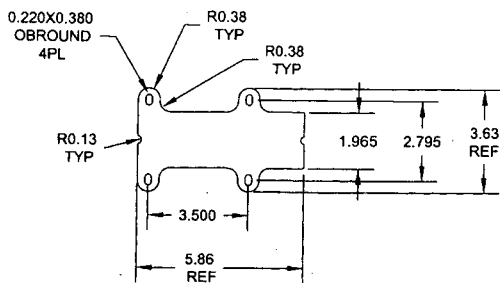
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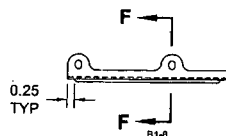


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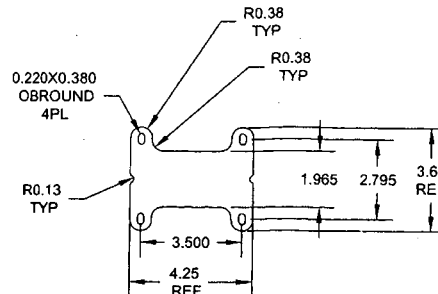
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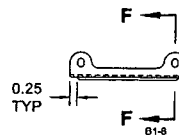
D4095-7F FLAT PATTERN 1



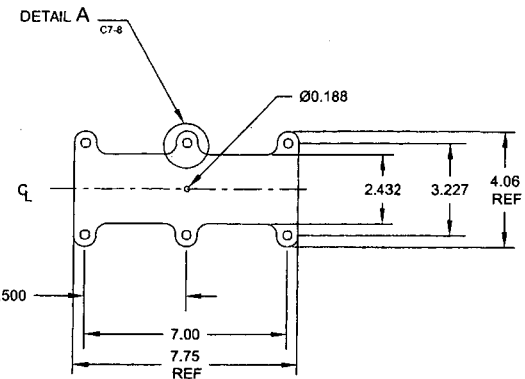
D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



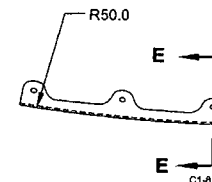
D4095-9F FLAT PATTERN 1



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



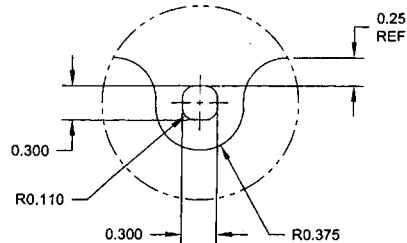
D4095-11F FLAT PATTERN 1



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

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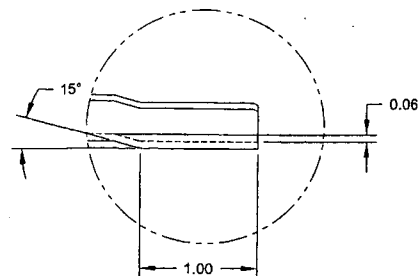
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DETAIL A: TAB DETAIL

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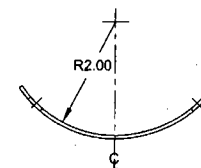
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

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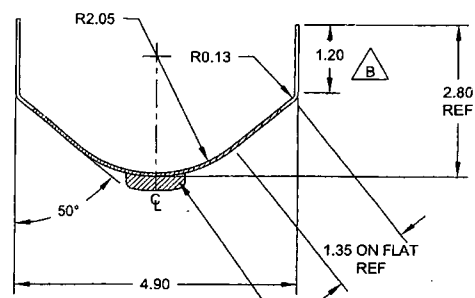
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B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

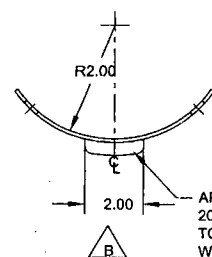


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

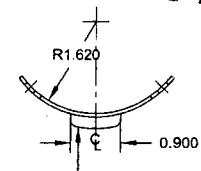


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

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